

Date: Tuesday, 15/07/2008 4:12:01 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 40516					
Estimate Number	: 10533					
P.O. Number	:			Part Number	: D2573	
This Issue	: 15/07/2008		S.O. No. :	Drawing Number	: D2573 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: E	
Previous Run	: 40198			Material	:	
Written By	:			Due Date	: 08/08/2008	
Checked & Approved By	: <u>JUL 08.7.16</u>			Qty:	10	Um: Each
Comment	: Est: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B34875</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>40516</u> Double check by: <u>J. A.</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:02 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 40516

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mf 08/08/20

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

mf 08/08/20

x10

7.0 POWDER COATING POWDER COATING



M108523

10X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:20

OVEN TEMPERATURE:

320

FINISH TIME:

9:50

mf 08/08/21

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



mf

08.08.21

x10

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST443

mf 08/08/21

10

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/08/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 4051(p)	
Description: Saddle, Aft Outboard				Part Number: D2573	
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.503	.502	.502	.504		
G	0.257	0.262		.266	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.501	.500	.500		
J	1.174	1.184		1.179	1.181	1.179	1.179		
K	0.558	0.578		.566	.566	.569	.567		
L	1.174	1.184		1.179	1.181	1.179	1.179		
M	1.365	1.375		1.368	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.500	2.499		
O	4.119	4.129		4.124	4.123	4.125	4.125		
P	0.115	0.135		.126	.124	.127	.126		
Q	0.115	0.135		.135	.135	.135	.125		
R	0.240	0.260		.249	.252	.252	.257		
S	0.115	0.135		.121	.120	.120	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.230	3.230	3.236		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.122	.123	.122	.121		
X	0.308	0.313		.316	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.766		
Z	0.352	0.372		.359	.365	.367	.363		
AA	0.470	0.530		.506	.500	.500	.500		
AB	0.615	0.635		.631	.634	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.244	.245	.244		
AE	1.500	1.520		1.512	1.512	1.514	1.513		
AF	0.115	0.135		.127	.127	.127	.130		
AG	0.240	0.280		.268	.265	.262	.261		
AH	0.240	0.260		.249	.251	.250	.250		
AI	2.000	2.020		2.006	2.000	2.003	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>JKL</i>	Audited by:	<i>JK</i>
Date:	08/08/18	Date:	08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JKL</i>	<i>JKL</i>

DART AEROSPACE LTD			Work Order:	40514
Description: Saddle, Aft Outboard			Part Number:	D2573
Inspection Dwg: D2573 Rev. E			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.440	.439"	.439"	.439"		
B	1.745	1.755		1.750	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500	3.501"	3.501"	3.501"		
D	1.745	1.755		1.750	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000	8.004"	8.004"	8.004"		
F	0.490	0.510		.507	.504"	.507"	.509"		
G	0.257	0.262		.260	.260	.260	.257"		
H	0.375	0.380		.378	.378	.378	.377"		
I	0.490	0.510		.501	.501	.500	.501"		
J	1.174	1.184		1.180	1.179	1.179	1.179"		
K	0.558	0.578		.565	.566	.567	.571"		
L	1.174	1.184		1.180	1.179	1.179	1.179"		
M	1.365	1.375		1.368	1.370	1.370	1.370"		
N	2.495	2.505		2.499	2.499	2.500	2.500"		
O	4.119	4.129		4.125	4.126	4.125	4.125"		
P	0.115	0.135		.127	.127	.127	.126"		
Q	0.115	0.135		.135	.135	.135	.130"		
R	0.240	0.260		.251	.251	.252	.252"		
S	0.115	0.135		.115	.119	.120	.125"		
T	0.178	0.198		.188	.188	.188	.188"		
U	3.210	3.250		3.230	3.228	3.229	3.230"		
V	0.230	0.250		.240	.240	.240	.239"		
W	0.115	0.135		.123	.120	.121	.125"		
X	0.308	0.313		.310	.311"	.311"	.311"		
Y	0.760	0.765		.761	.760"	.760"	.761"		
Z	0.352	0.372		.365	.364"	.362"	.369"		
AA	0.470	0.530		.500	.500	.500	.500"		
AB	0.615	0.635		.635	.635"	.634"	.634"		
AC	0.053	0.073		.063	.063	.063	.063"		
AD	0.240	0.260		.241	.242	.246	.250"		
AE	1.500	1.520		1.513	1.513	1.515	1.513"		
AF	0.115	0.135		.131	.125	.127	.135"		
AG	0.240	0.280		.265	.265	.265	.273"		
AH	0.240	0.260		.249	.248	.248	.251"		
AI	2.000	2.020		2.002	2.002	2.004	2.002"		
AJ	0.023	0.043		.033"	.033"	.033"	.033"		

Accept/Reject

Measured by:	J.F.	Audited by:	88
Date:	08/08/18	Date:	08/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK JLM

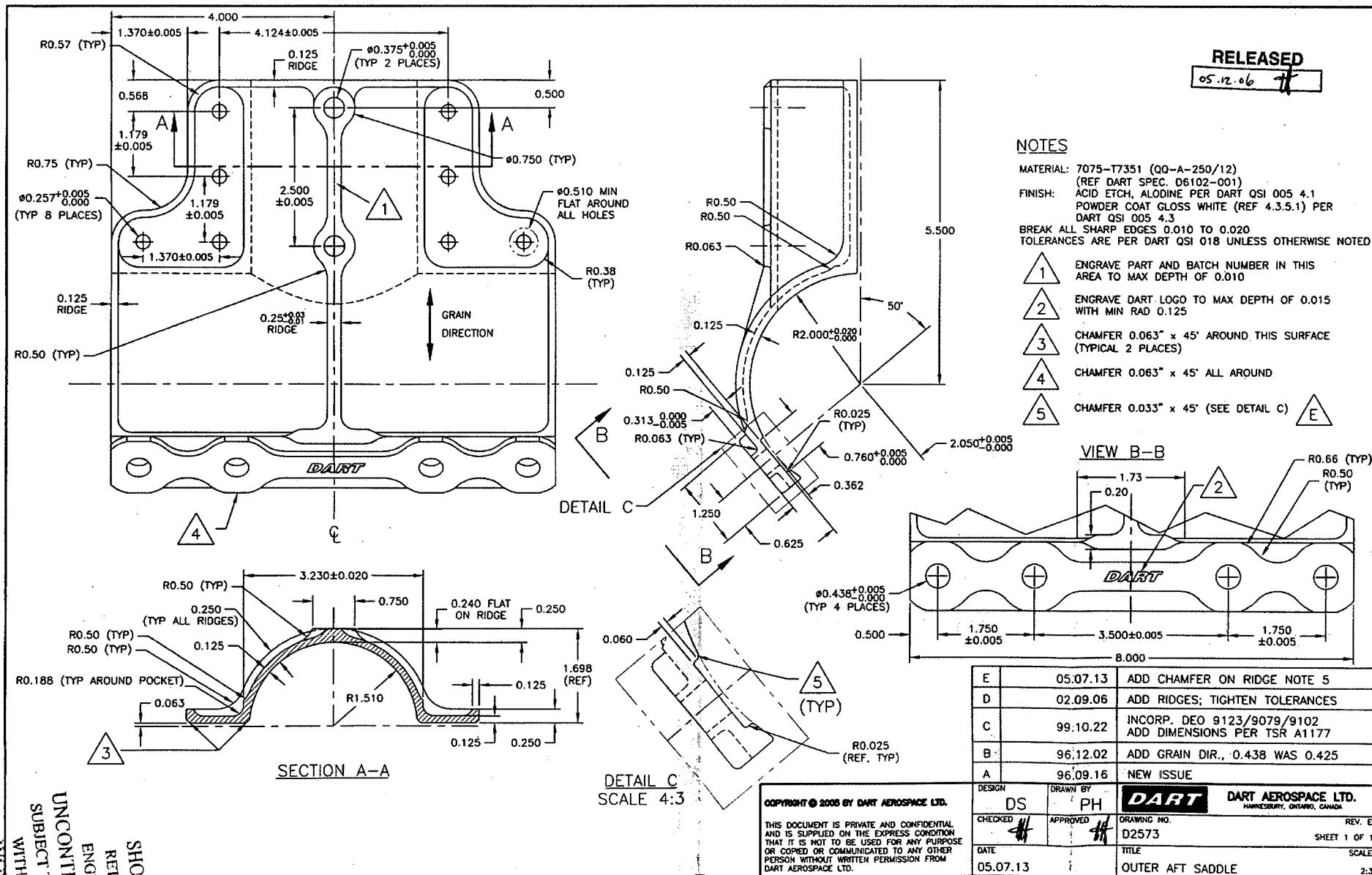
DART AEROSPACE LTD			Work Order:	40516
Description: Saddle, Aft Outboard			Part Number:	D2573
Inspection Dwg: D2573 Rev. E			Page 1 of 1	

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B	1.745	1.755		1.750"	1.750"					
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N	2.495	2.505		2.500"	2.500"					
O	4.119	4.129		4.125"	4.125"					
P	0.115	0.135		.126"	.124"					
Q	0.115	0.135		.130"	.130"					
R	0.240	0.260		.251"	.250"					
S	0.115	0.135		.120"	.124"					
T	0.178	0.198		.188"	.188"					
U	3.210	3.250		3.230"	3.230"					
V	0.230	0.250		.239"	.238"					
W	0.115	0.135		.124"	.125"					
X	0.308	0.313		.312"	.311"					
Y	0.760	0.765		.761"	.761"					
Z	0.352	0.372		.370"	.370"					
AA	0.470	0.530		.500"	.500"					
AB	0.615	0.635		.635"	.630"					
AC	0.053	0.073		.063"	.063"					
AD	0.240	0.260		.250"	.250"					
AE	1.500	1.520		1.513"	1.512"					
AF	0.115	0.135		.135"	.135"					
AG	0.240	0.280		.273"	.223"					
AH	0.240	0.260		.251"	.251"					
AI	2.000	2.020		2.003"	2.002"					
AJ	0.023	0.043		.033"	.033"					
Accept/Reject										

Measured by:	JF	Audited by:	LB
Date:	08/08/20	Date:	08/08/20

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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	RF



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